

Date: Monday, 4/23/2007 1:52:40 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 31994		
Estimate Number	: 12722		
P.O. Number	: <i>N/A</i>	Part Number	: D353615
This Issue	: 4/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3536 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 30753	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/30/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 1.0340 sf(s)/Unit Total : 20.6808 sf(s)  
 NEOPRENE SHEET 0.063  
 Batch: *M103104*

*JAW 07/05/03*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3536  
 Dwg Rev: *A*  
 Prog Rev: *A*

*SAD 07/05/03*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/03*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SC 07.05.03*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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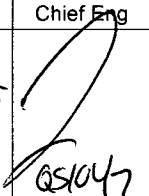
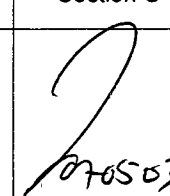
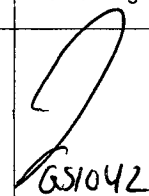
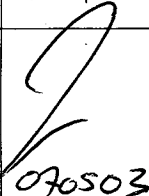
Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: *Finish*

*7/5/4 59 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/03	2.0	2 parts were Not in tolerance. Cut without a cover on the material	 QS1042	Scrap & destroy and <u>replace</u>	SAD 07/05/03	 070503	 QS1042	 070503

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31994

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

1207/05/07

Job Completion



1207/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	31994
<b>Description:</b> Gasket		<b>Part Number:</b>	D3536-15
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.14	✓		M-T/Vern	
35.65	+/-0.030	35.64	✓		M-T/Vern	
33.65	+/-0.030	33.64	✓		M-T/Vern	
30.15	+/-0.030	30.15	✓		M-T/Vern	
24.90	+/-0.030	24.89	✓		M-T/Vern	
19.65	+/-0.030	19.64	✓		M-T-Vern	
14.40	+/-0.030	14.39	✓		M-T/Vern	
9.15	+/-0.030	9.14	✓		Vern	
5.65	+/-0.030	5.628	✓		Vern	
3.90	+/-0.030	3.89	✓		Vern	
8.00	+/-0.030	7.98	✓		Vern	
16.00	+/-0.030	16.02	✓		M-T/Vern	
24.00	+/-0.030	24.012	✓		M-T/Vern	
0.30	+/-0.030	0.312	✓		Vern	
0.30	+/-0.030	0.315	✓		Vern	
1.89	+/-0.030	1.910	✓		Vern	
Ø0.19	+0.005/-0.004	Ø0.197	✗		Vern	
Ø2	±0.030	Ø0.212 Ø0.199	✓		Vern	

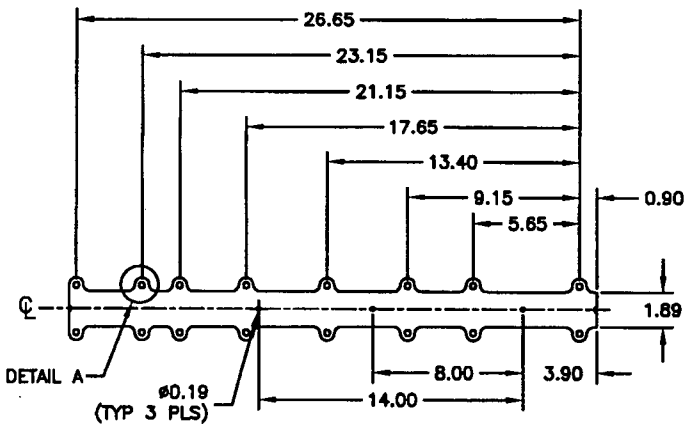
<b>Measured by:</b>	SAD	<b>Audited by:</b>	[Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/05/03	<b>Date:</b>	07.05.03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

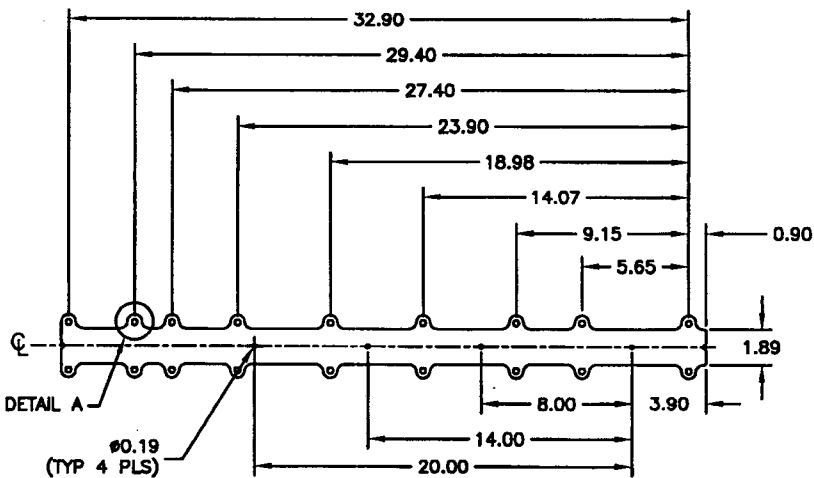
# DART

09.02.12 -

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CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	[Signature]	D3536	SHEET 1 OF 6
DATE		TITLE	SCALE
06.10.25		GASKET	1:10
A	06.10.25	NEW ISSUE	



**D3536-11 GASKET**



**D3536-13 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WITHOUT NOTICE  
WORK ORDER  
NO. 31994

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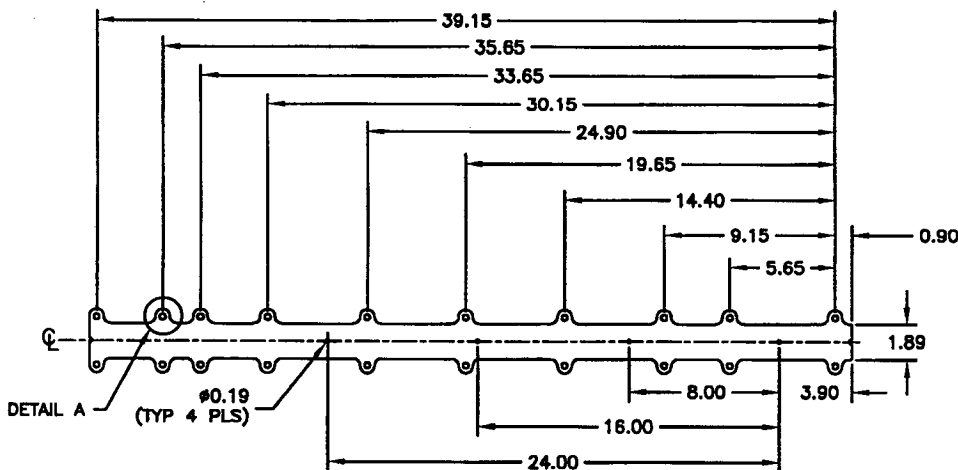
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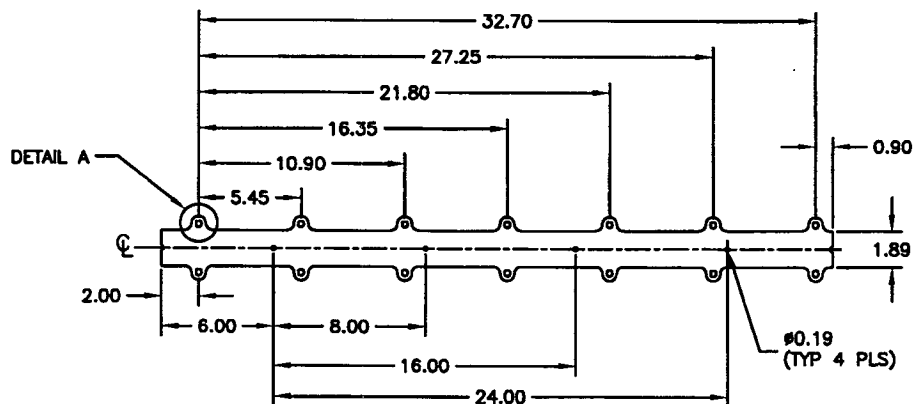
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DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 2 OF 6	SCALE <b>1:10</b>

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**D3536-15 GASKET**



**D3536-21 GASKET**

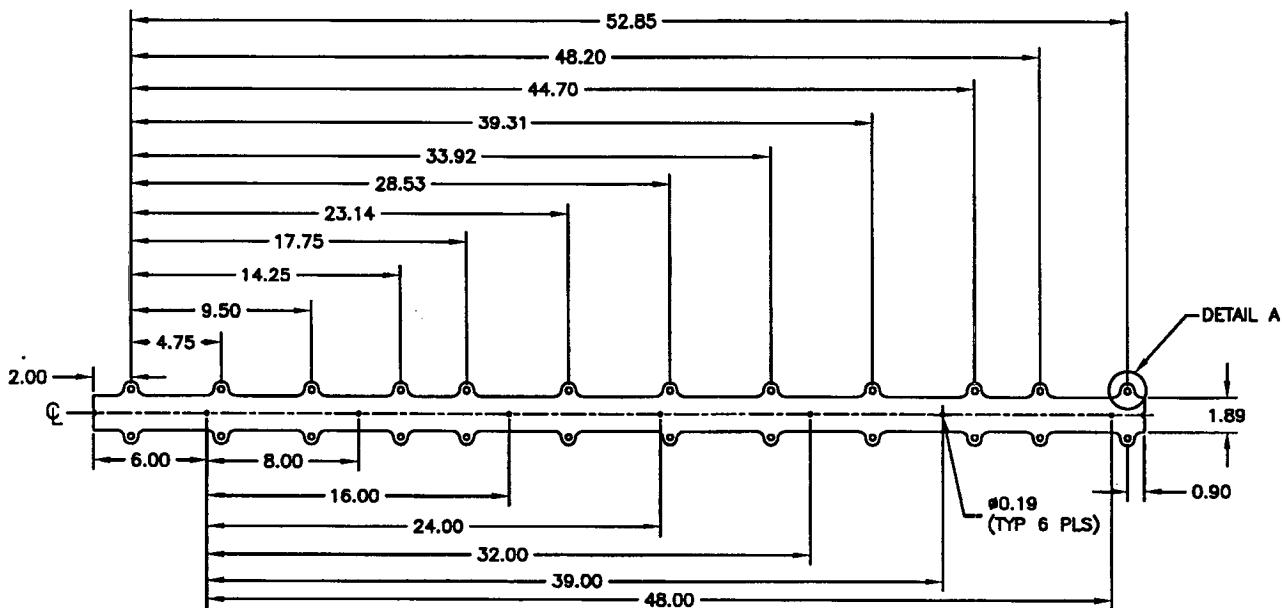
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- NOTES
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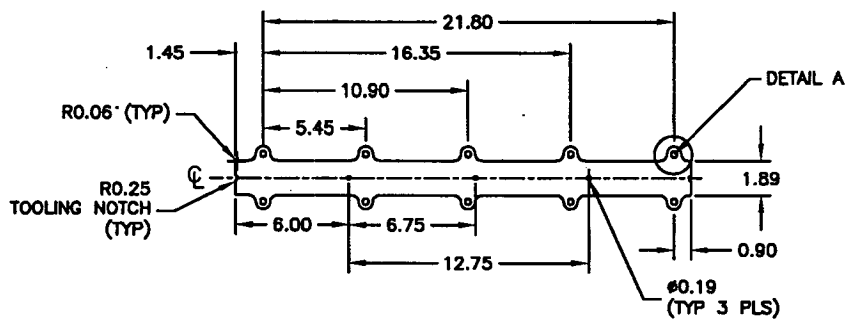
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DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

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**D3536-23 GASKET**



**D3536-25 GASKET**

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**NOTES**

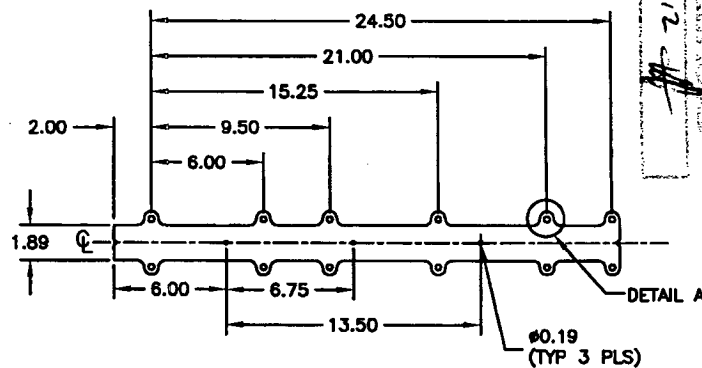
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- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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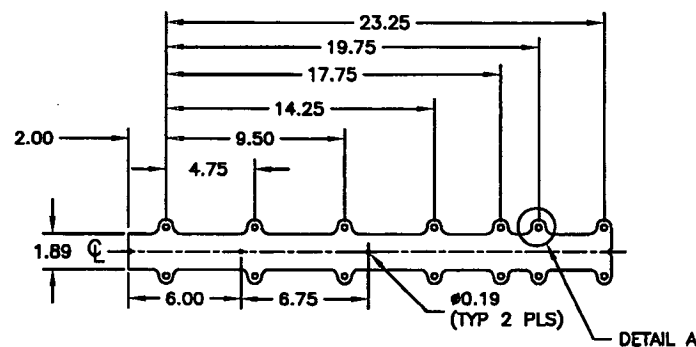
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DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

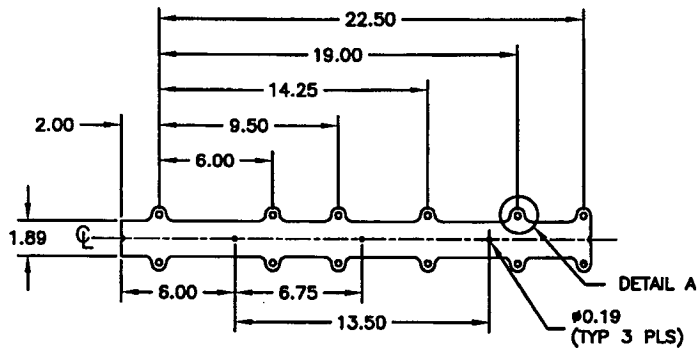
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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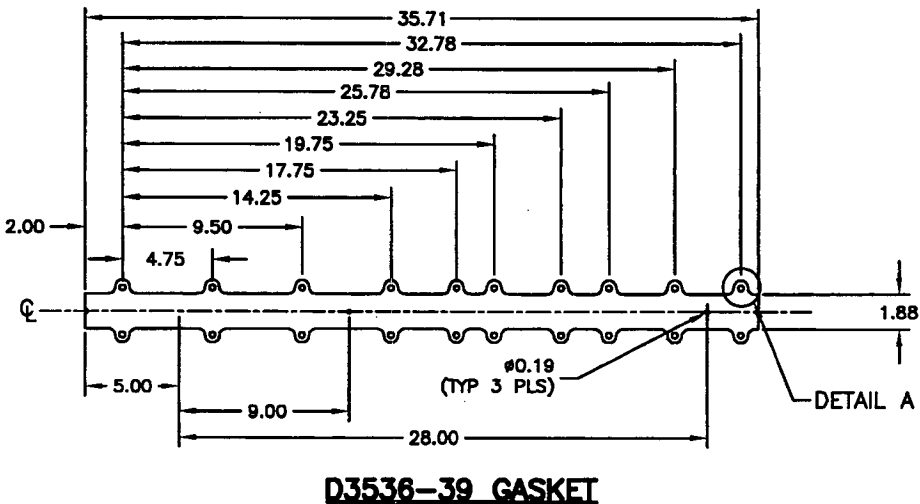
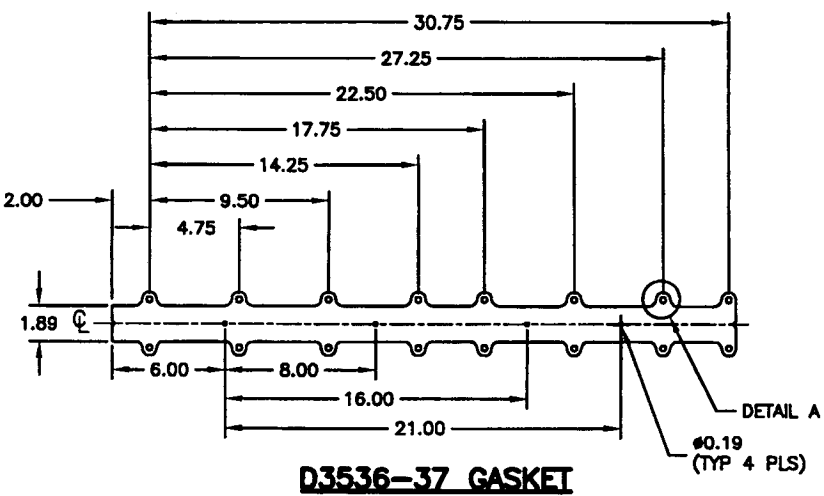
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DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 5 OF 6	SCALE <b>1:10</b>

07.02.12  
07.02.12  
07.02.12



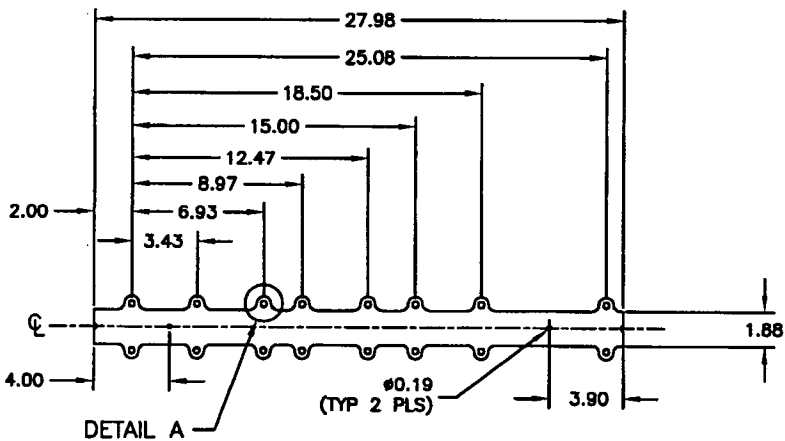
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  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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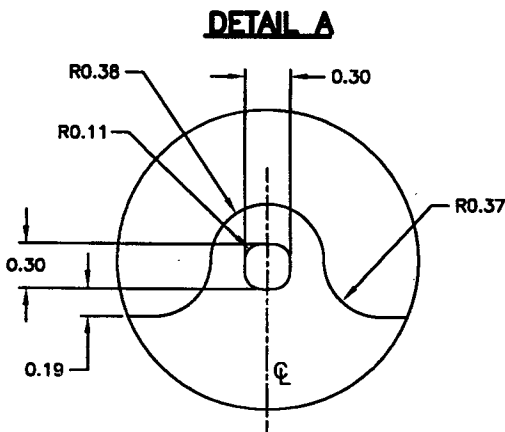
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DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 6 OF 6
	SCALE <b>1:10</b>	

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07.01.22 *[Signature]*



**D3536-41 GASKET**



**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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